

*BLUE*

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:00 PM  
User: Julie Dawson

### Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: 02.250 SUPPORT	
Job Number	: 43383				Part Number	: D28911	
Estimate Number	: 11057				Drawing Number	: D2891-BLUE	
P.O. Number	:				Project Number	: N/A	
This Issue	: 12/11/2008 S.O. No. :				Drawing Revision	: A1	
Prsh Rev.	: NC				Material	:	
First Issue	: / / Type : PURCHASED PARTS				Due Date	: 10/12/2008 Qty: 12 Um: Each	
Previous Run	: 41198						
Written By	:						
Checked & Approved By	: <u>JD 08.11.12</u>						
Comment	: Est. C 02.11.26 Added P/O KJ Est D 08.03.19 Re-format EC verified: DD						

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DSK076	D2891-1 TURNING DETAIL	
		Comment: Qty.: 0.5000 Each(s)/Unit Total : 6.0000 Each(s) D2891-1 TURNING DETAIL Batch: <u>B42244</u> mwe 08/11/23	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS Machine as per Folio FA046 Tumble & Deburr	mwe/J.L 08/11/25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	mwe/J.L 08/11/25
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	29 08/11/29 (P)
5.0	SPRAY PAINTING	SPRAY PAINTING	
		Comment: -PRIME B <u>109992</u> -PAINT DELFLEET BLUE B <u>110077</u> -CLEAR DELFLEET B <u>110161</u>	CT 08-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
00/00/00	00/00	<del>100% of parts are being placed in the wrong place</del>						

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:01 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 43383

Part Number: D28911

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC14

INSPECT SPRAY PAINT



M 08 12 11

(12)



Comment: INSPECT SPRAY PAINT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: x-tube Ass

M

08 12 11

(12)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-1211

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43383
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
<b>HAAS Section</b>								
AA	0.188	0.193		.191	.192	.192	.191	.191
AB	0.240	0.260		.250	.247	.253	.249	.250
AC	0.115	0.150		.128	.127	.130	.128	.129
AD	0.040	0.060		.049	.048	.048	.049	.049
AE	0.010	0.020		.010	.011	.011	.011	.011
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.310	.296	.290	.297	.295
AH	0.115	0.150		.142	.140	.140	.141	.141
AI	0.454	0.474		.456	.460	.463	.461	.457
AJ	2.779	2.789		2.783	2.782	2.781	2.781	2.782
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.036	1.042	1.041	1.041	1.042
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.260	.261	.261	.261	.261
AO	1.663	1.683		1.671	1.671	1.671	1.671	1.669
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.031	.031	.031	.031	.031
AR								
AS								
AT								
Accept/Reject								

Measured by: MWE Date: 06/11/24

Audited by: JMK Date: 08/10/02

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	JL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO.

DART AEROSPACE LTD

Work Order:

143383

Description: Ø2.250 Support

Part Number:

D2891-1

Inspection Dwg: D2891

Rev: A1

Page 1 of 1

## FIRST ARTICLE INSPECTION DIMENSION SHEET

 First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	0.188	0.193		.191	.191	.191	.191	.191
AB	0.240	0.260		.255	.255	.250	.245	.245
AC	0.115	0.150		.129	.129	.127	.130	.127
AD	0.040	0.060	.049	.049	.049	.049	.051	.050
AE	0.010	0.020	.011	.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.293	.300	.300	.300	.300
AH	0.115	0.150		.141	.140	.140	.140	.140
AI	0.454	0.474		.459	.461	.461	.462	.462
AJ	2.779	2.789		2.781	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.042	1.034	1.034	1.032	1.037
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.261	.261	.261	.261	.261
AO	1.663	1.683		1.669	1.673	1.673	1.673	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.031	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by:

mtc / JL

Date: 08/11/25

Audited by:

mz

Date: 08/12/02

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	gut

DART AEROSPACE LTD	Work Order:	43383
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
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HAAS Section								
AA	0.188	0.193		.191	.191			
AB	0.240	0.260		.249	.250			
AC	0.115	0.150		.127	.127			
AD	0.040	0.060		.048	.049			
AE	0.010	0.020		.015	.015			
AF	0.240	0.260		.250	.250			
AG	0.290	0.310		.300	.300			
AH	0.115	0.150		.140	.140			
AI	0.454	0.474		.460	.460			
AJ	2.779	2.789		2.784	2.784			
AK	0.240	0.260		.250	.250			
AL	1.002	1.042		1.035	1.031			
AM	0.053	0.073		.063	.063			
AN	0.257	0.262		.261	.261			
AO	1.663	1.683		1.671	1.672			
AP	0.053	0.073		.063	.063			
AQ	0.022	0.042		.032	.032			
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L Date: 08/11/25

Audited by: J.M Date: 08/12/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	J.L

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS  
HEAT TREAT TO H900  
(900°F FOR 1 HR, AIR)  
MIN UTS = 170 KSI
- 2) IDENTIFY WITH DART LOGO (PER GRAPHIC) AND PART NUMBER  
0.125 HIGH LETTERING 0.010
- 3) BREAK ALL UNMARKED SHARP
- 4) PART IS SYMMETRIC ABOUT CEN
- 5) TOLERANCES ARE PER DART QS  
 $X.XXX = \pm 0.010$ ) UNLESS OT
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (F  
QSI 005 4.3

Ø0.188

(TYP 2 PLACES)

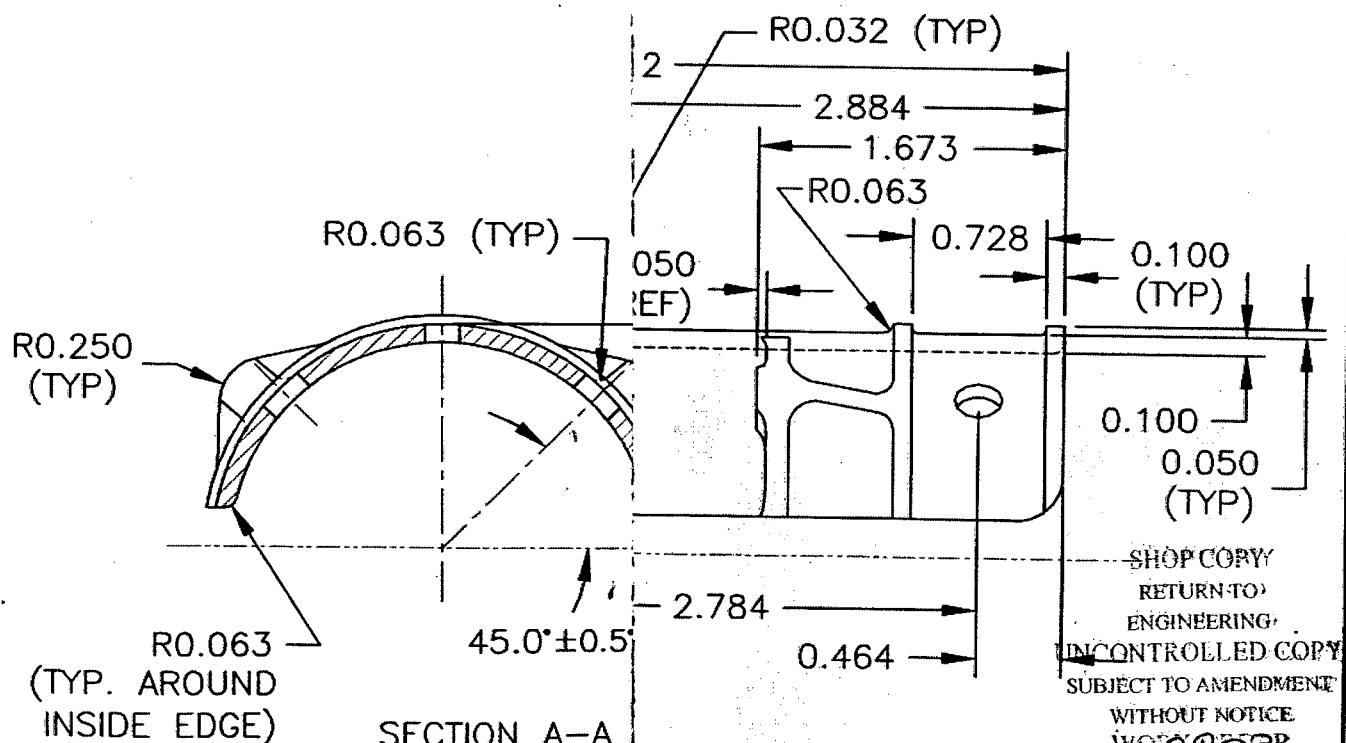


2

Ø0.257 (TYP 4 PLACES)

0.250 SPHERICAL RADIUS  
FAIRING FLANGES TO  
MAIN BODY (TYP)

R0.250 (TYP)



02.01.23	UPDATE DIMS AS MANUFACTURED.
00.11.17	NEW ISSUE
DRAWN BY <i>CP</i>	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
PROVED <i>[Signature]</i>	DRAWING NO. D2891 REV. A
	SHEET 1 OF 1
	SCALE 1:1
	TITLE Ø2.250 SUPPORT